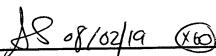
Dart Aerospace Ltd. Friday, 15/02/2008 11:49:27 AM ate: Jean-Luc Menard User **Process Sheet** : BOLT **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 37478 **Job Number** : 10372 **Estimate Number** : D312121 Part Number P.O. Number : D3121 REV E **Drawing Number** S.O. No. : : 15/02/2008 This Issue : N/A Project Number : NC Prsht Rev. : E **Drawing Revision** : 11 MACHINED PARTS First Issue **Material** : 36668 **Previous Run** Qty: 60 Um: Each : 22/02/2008 **Due Date** Written By Checked & Approved By A04.02.09 New issue KJ/DS : Est. Comment Est Rev:B ECN 1060 07-11-12 DD verified by:EC **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 303 HEX BAR M303H0500 1.0 Total: 2.5020 f(s) Comment: Qty.: 0.0417 f(s)/Unit 303 HEX BAR Material: AISI 303 SS 1/2" Hex Bar (M303H0.500) Batch: M106789 HARDINGE CNC LATHE SMALL HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-21 2-Identify as D3121-21 3-Deburr break all sharp edges 0.005" to 0.010" INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 60 08.02.18 **Comment: SECOND CHECK** PACKAGING RESOURCE #1 PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

55 66



Date: User: Friday, 15/02/2008 11:49:27 AM

Jean-Luc Menard

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: BOLT** 

Job Number: 37478

Part Number: D312121

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

**Job Completion** 

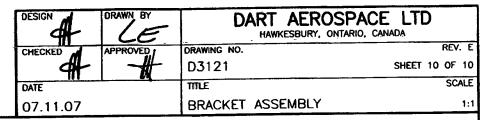


2008/2/19









D3121-21 BOLT (SCALE 1:1)

NONE

4) ALL DIMENSIONS ARE IN INCHES

OTHERWISE NOTED

1) MATERIAL: AISI 303 SS HEX, ANNEALED

3) TOLERANCES ARE PER DART QSI 018 UNLESS

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

0.230±0.001

TAP 10-32

UNF-3A

0.050 TO 0.060

0.080

(REF DART SPEC. M303H0.500)

0.315

D\ 1.000 0.838

R0.063

±0.002

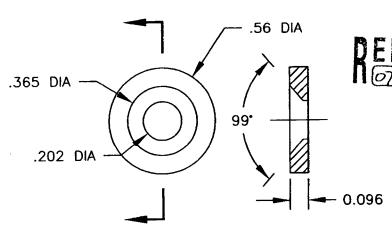
R0.010

0.865

 $\pm 0.001$ 

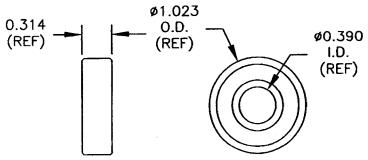
0.375 -

2) FINISH:



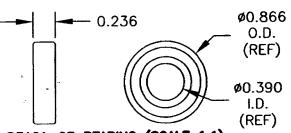
## D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



## D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



## D3121-23 BEARING (SCALE 1:1)

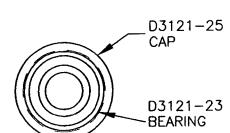
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- ALL DIMENSIONS ARE IN INCHES

1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

D3121-25 CAP (SCALE 1:1)



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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DART AEROSPACE LTD	Work Order:	
Description: Bolt	Part Number:	D3121-21
Inspection Dwg: D3121 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	،375				
0.050 - 0.060	N/A	0.058				
0.080	+/-0.010	0.078				
10-32UNF3A	N/A	Ø.187				
Mow	min . 212 max . 214	,213				
		,				

Measured by: H.A/M	Audited by:	156	Prototype Approval:	N/A
Date: 08/02/17	Date:	05-02.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
			KJ/RF	
Α	04.02.27	New Issue	KJ/JLM	
В	06.03.09	Dwg Rev. updated		<u> </u>
		Dwg Rev. updated	KJ/JLM 1.A	
			KJ/EC/DD	
D	08.01.16	Dwg Rev. updated	LIGITOIDE	